

20-7962



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U/R

S/M
19/08/31

D2275

Job Sheet 198689



EFFECTIVE 7/13/17 AUTH. S.A.G.

RELEASED _____ DATE _____

Part No: D2275

Job Qty: 20 pcs

Part Name: Bushing



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/1/19

Job Tracking No:

Due Date: 8/15/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: URF 19-637 DWG REV C IPP E 02.03.27 Added in house machining NG

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Hardinge - 1	20 pcs	8/15/19	8/15/19	0.21	3.24	Hardinge - 1		19/08/02
120	QC 8	20 pcs	8/15/19	8/15/19	0.00	0.00	QC 8 - 12		19-08-03
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		
130	Packaging 3-1 - Stock - B4B	20 pcs	8/15/19	8/15/19	0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		

DAS
65
9-89

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				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	5
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140 QC 21 - SA	20 pcs	8/15/19	0.00 0.00	QC 21 - SA - 21	AUG 14 2019
				QC 21 - SA - 70	
				QC 21 - SA - 53	
Part Op 100 - (Hardinge) Machine as per Folio FA 213 Tumble & deburr all sharp edges Descriptions: 120 - (QC8- Inspect parts - second check) 130 - (Identify as per dwg & Stock Location: _____) *** STOCK IN STEP CELL*** LOCATION : WA003 140 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M6061T6R1.250	6061-T6 Round Bar 1.250	3.3340 ft (.1667 ea)	100-Hardinge - 1	2100 546	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Hardinge - 1	M6061T6R1.250	3	20	0	

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bushing	1.975Inches ± 0.010	1.985 1.965		
2	Bushing	1.500Inches ± 0.010	1.510 1.490		
3	Bushing	0.750Inches ± 0.010	0.760 0.740	Diameter	
4	Bushing	0.100Inches ± 0.030	0.130 0.070		
5	Bushing	45.000Degrees ± 0.500	45.500 44.500	Angle	
6	Bushing	0.257Inches + 0.006 - 0.001	0.263 0.256	Diameter	
7	Bushing	1.250Inches ± 0.030	1.280 1.220		

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Entered: JK Date: 19-08-05

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE



NCR No. 20-7962

Route update only

Job: <u>198689</u>		DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Engineering ☐ Machining ☒ Small Fab ☐ Prod. Eng. Coord. ☐ Water Jet ☐ Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Supplier Quality ☐						
Date :	Sequence #:		QTY Affected : <u>17</u>				MRB (QSI042) DAS 55 9-89 <u>19-08-03</u>			
Description Work Order Deviation			Disposition				Completed By <u>JBD 19-08-03</u>			
-1 Part was undersize on the length -2 Parts were damaged			scrap				Lead hand / Supervisor DAS 20 9-89 <u>19-08-03</u>			
							QC / QA Coordinator DAS 55 9-89 <u>19-08-03</u>			
Root Cause			FAULT CATEGORY							
Operator ☐			☐ Pressure/Forced	☐ Contamination	☐ Power Loss/Surge	☐ Positioned Wrong				
Manufacturing Process ☒			☐ Bending	☐ Misaligned/off center	☐ Folio/Program	☒ Outside Tolerance				
Equip/Tooling ☐			☐ Crushing	☐ BOM/Route	☐ Grain Direction	☐ Drawing				
Handling/Presservation ☐			☐ Cracks	☒ Broken/Damage/Defect	☐ Weld	☐ Finish				
Material ☐			☐ Crimp/Kink/Ripple/Wave/Twist	☐ Incomplete/Unclear Instructions	☐ Wrong Stock Pulled	☐ Part Lost/Missing				
Product Improvement ☐			☒ Marks/Chatter	☐ Drill Holes	☐ Out of Sequence	☐ Misread				
Process Improvement ☐			☐ Mislabeled	☐ Fit/Function	☐ Off-set/Set-up					
Human Factors ☐			Other/Details:							